FIG.21

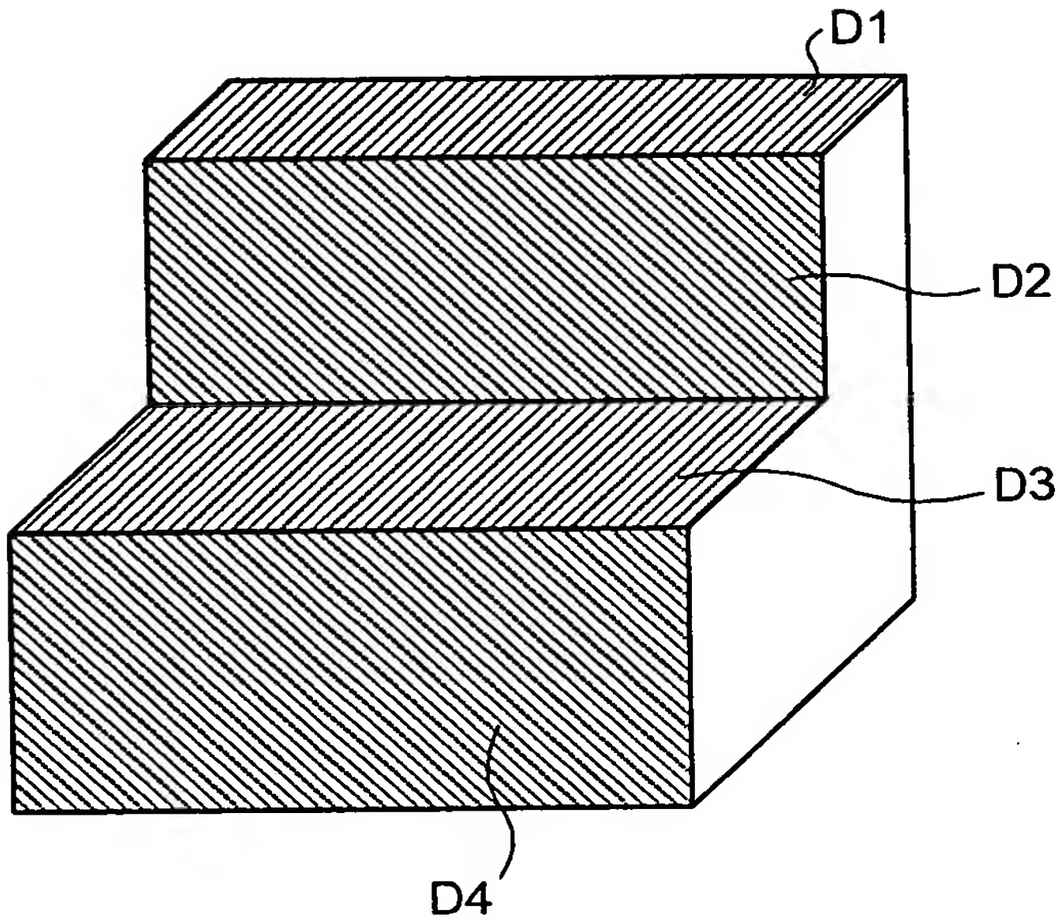


FIG.22

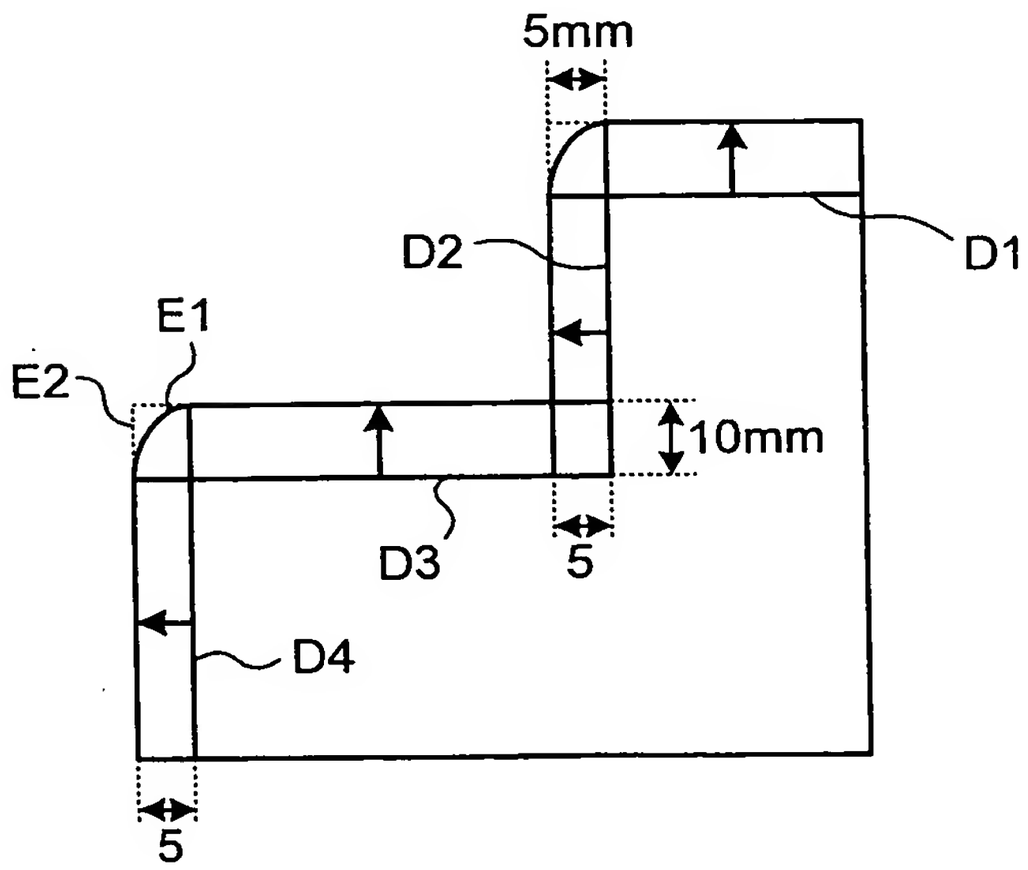


FIG.30

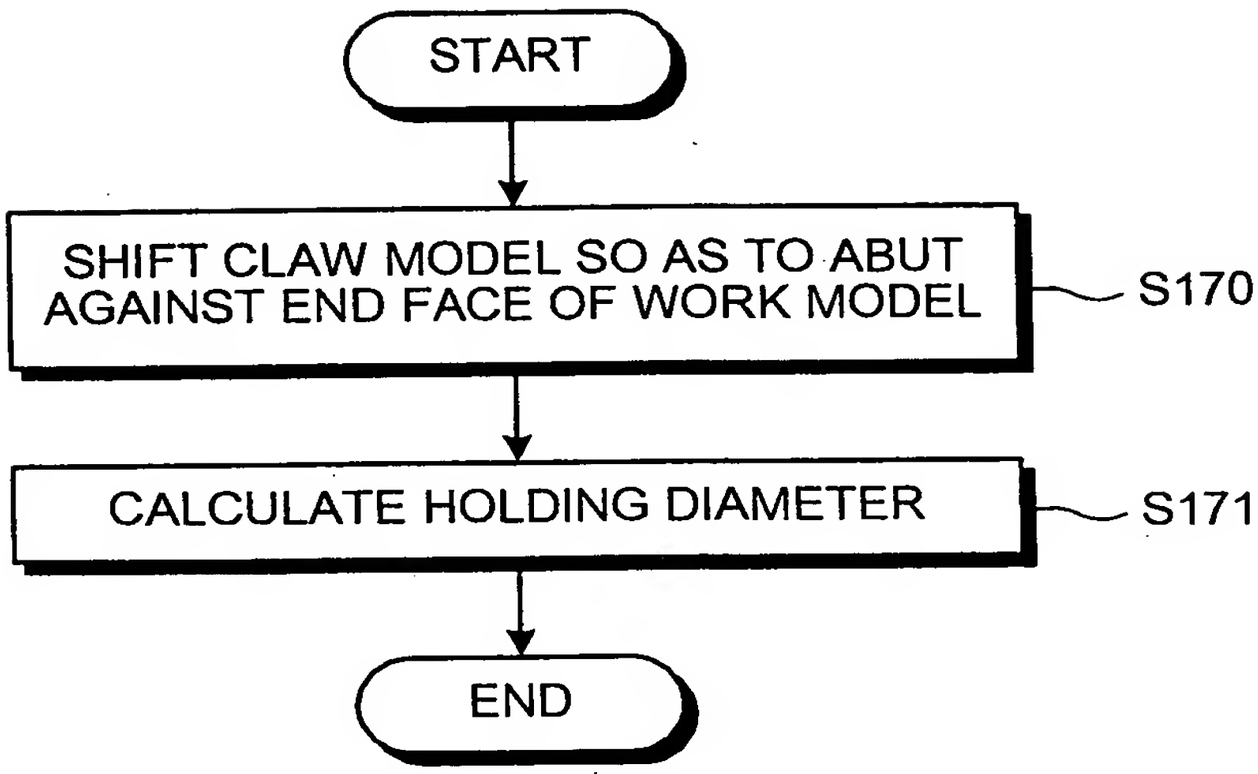
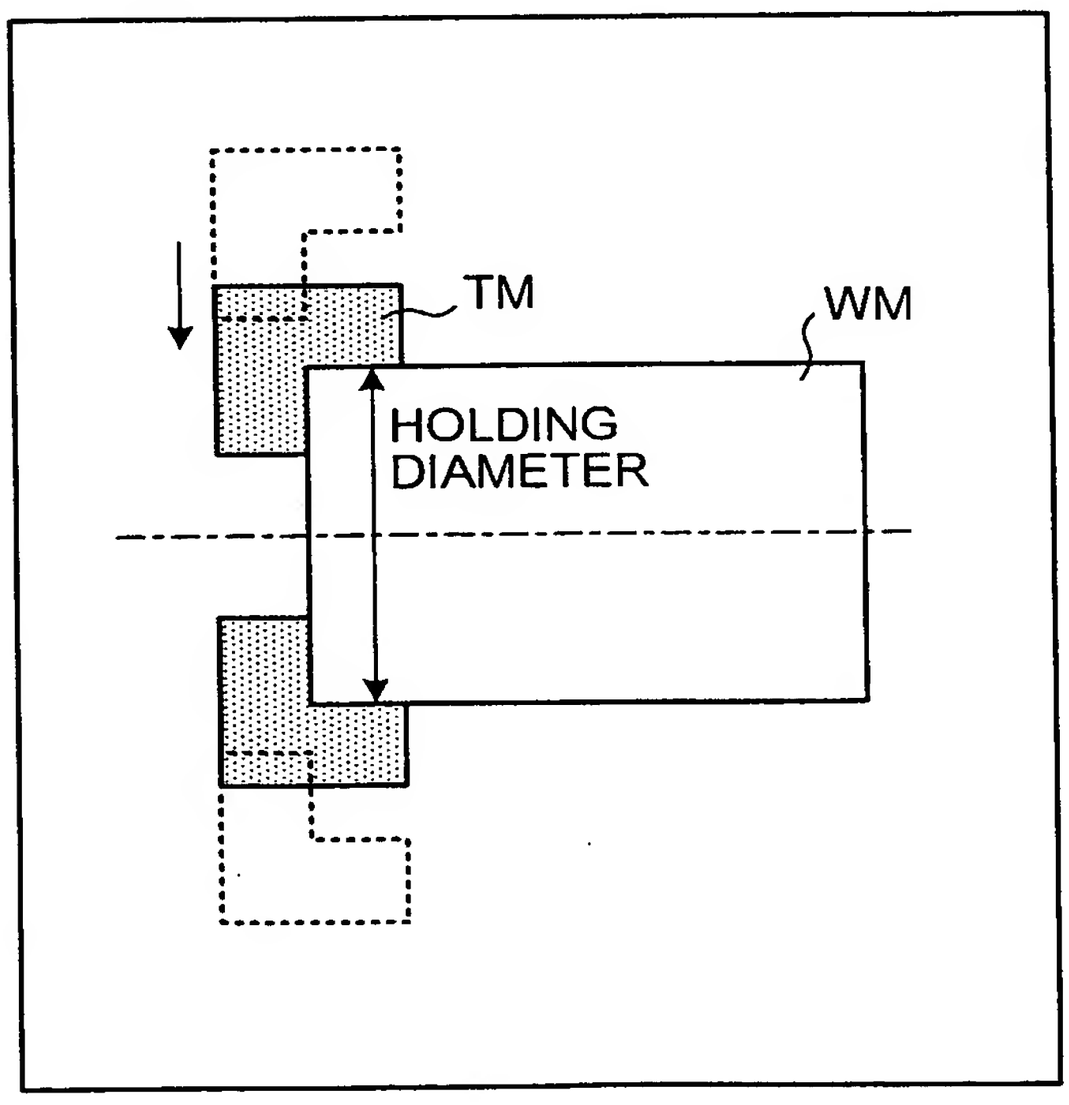

START
SHIFT CLAW MODEL SO AS TO ABUT AGAINST END FACE OF WORK MODEL
S170
CALCULATE HOLDING DIAMETER
S171
END

FIG.31


TM
WM
HOLDING DIAMETER